

ASAP

Work Order ID 110102

110102

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December-17-13 9:15:02 AM

Item ID: D4542-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Retainer, Inner
 Start Date: 12/17/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 13-12-19 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4542	D								

100 0.00
 100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1- Cut as per dwg
 Prog rev: D
 Dwg rev: D
 2- Deburr
 110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00
 Quality Control
 4 0 14-01-26
 4 0 14-01-26

Work Order ID 110102

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Page 2

Item ID: D4542-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Retainer, Inner
 Start Date: 12/17/13 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 DAS 16 0.00 9-89 14/11/27				(X)			
125 *125* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	7/6	14-1-27	
127 *127* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 DAS 16 0.00 9-89 14/11/27				(X)			

December-17-13 9:15:02 AM

Item ID: D4542-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Retainer, Inner

Stop *NS2*

Start Date: 12/17/13 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 12/17/13 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

Identify as per dwg & Stock Location:_____

0.00

130

PPP 111468

0.00

Packaging

Memo

Packaging

4x ^{DAS}
28 14-01-27
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 14-01-27

Picklist Print

December-17-13 9:15:01 AM

Page 1

Work Order ID: 110102

Parent Item: D4542-5

Parent Item Name: Retainer, Inner

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 4.00

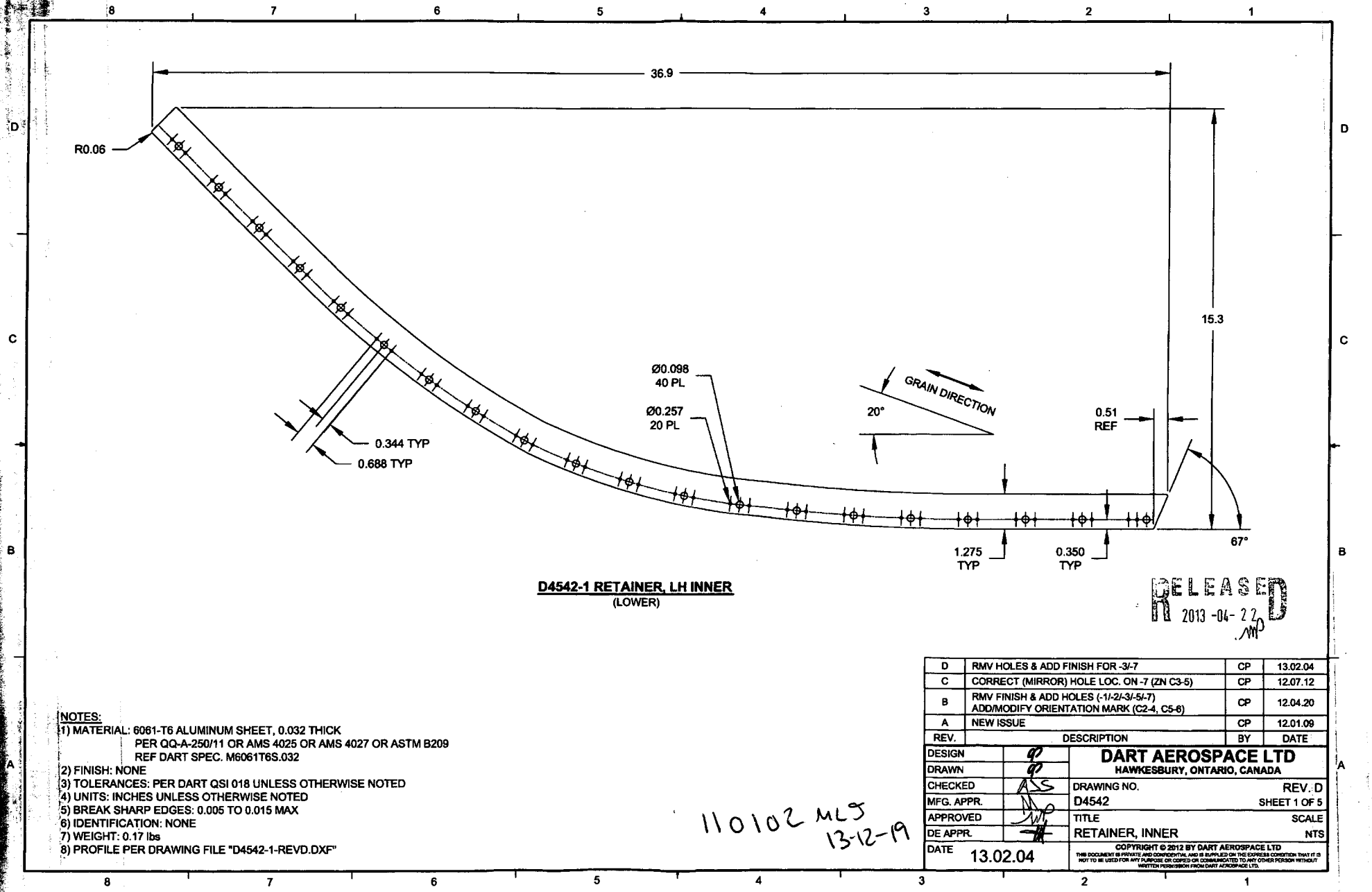
Required Qty: 4.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B 12.02.24 as per dwg
 reva DD verf:EC IPP REV:C 12.05.08 as per dwg revB DD verf:EC IPP
 REV:D 13.04.23 as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No			100	sf	518.9060	0.208	0.8757896		14-01-26	

Location	Loc Qty	Loc Code
MAT021	518.906	
123483	255.65	
m125822	48.1	
m126115	60.356	
m126309	53.31	
<u>m127272</u>	101.49	

127272 → .9



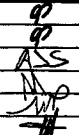
D4542-1 RETAINER, LH INNER
(LOWER)

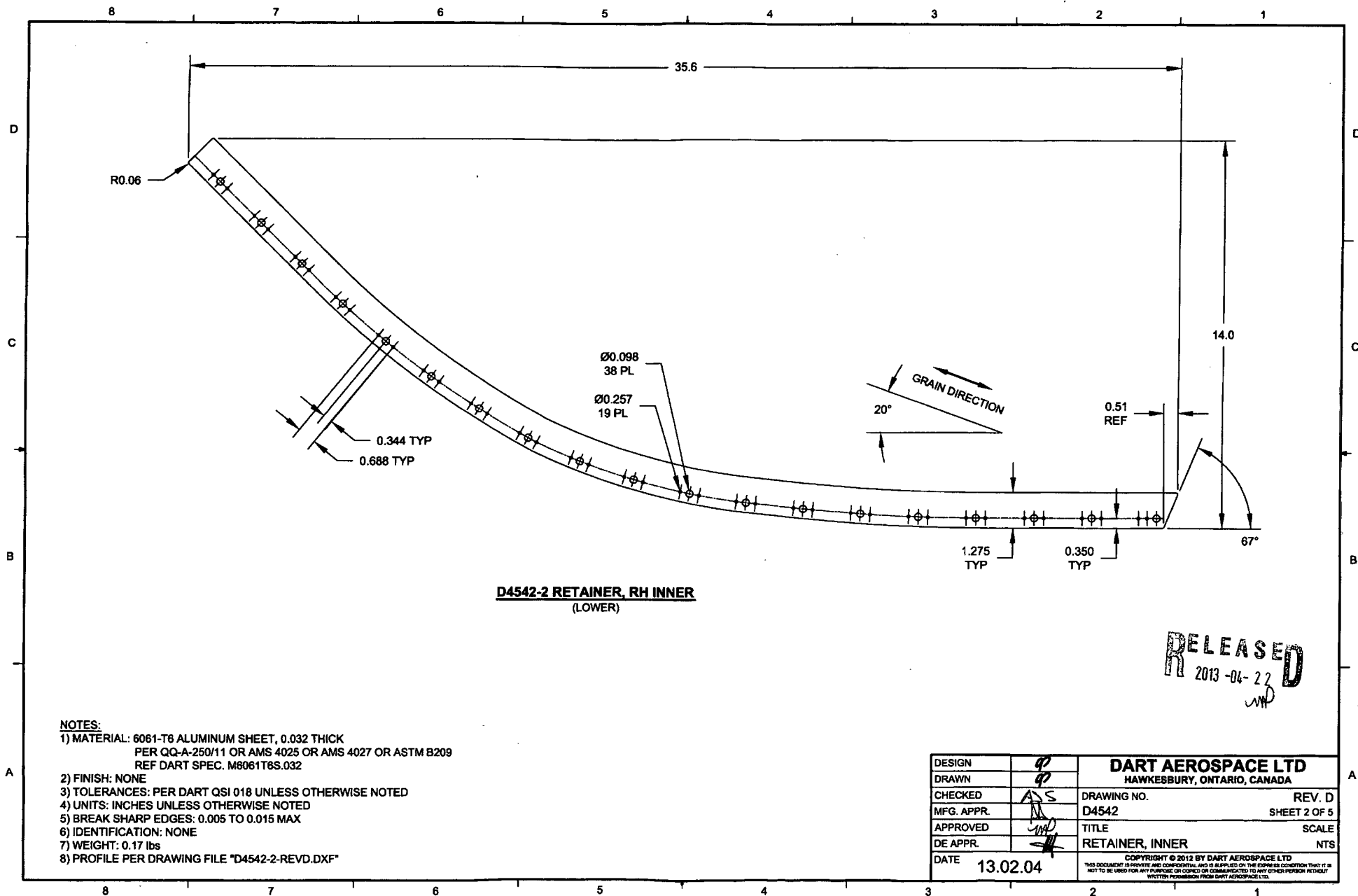
RELEASED
2013-04-22

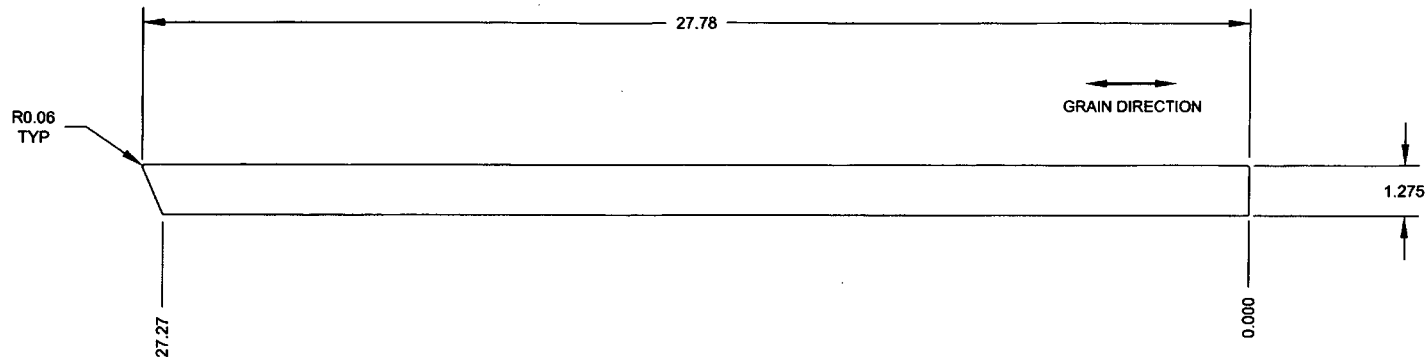
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs
- 8) PROFILE PER DRAWING FILE "D4542-1-REVD.DXF"

110102 MJS
13-12-19

D	RMV HOLES & ADD FINISH FOR -3/-7	CP	13.02.04
C	CORRECT (MIRROR) HOLE LOC. ON -7 (ZN C3-5)	CP	12.07.12
B	RMV FINISH & ADD HOLES (-1/-2/-3/-5/-7) ADD/MODIFY ORIENTATION MARK (C2-4, C5-6)	CP	12.04.20
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.02.04	DRAWING NO.	REV. D
		D4542	SHEET 1 OF 5
		TITLE	SCALE
		RETAINER, INNER	NTS
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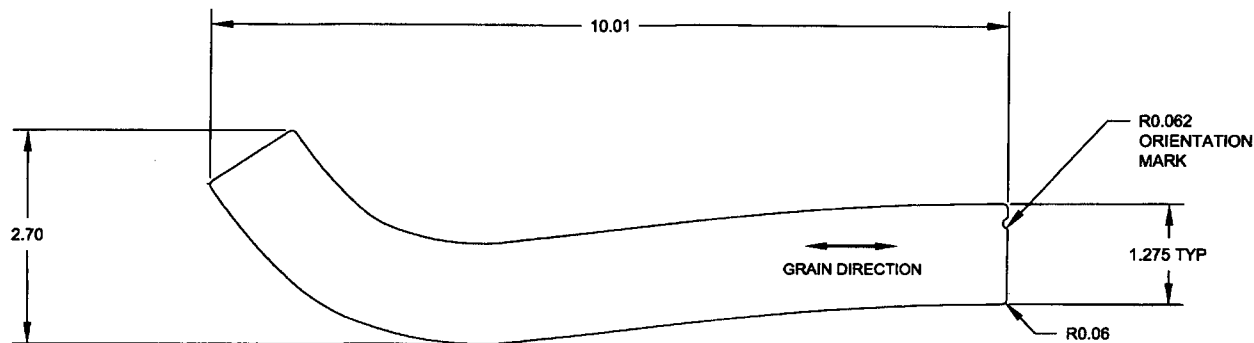
D4542-3 RETAINER, INNER
(SIDE) 

RELEASED
2013-04-22
md

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.11 lbs
- 8) PROFILE PER DRAWING FILE "D4542-3-REVD.DXF"

DESIGN	<i>g</i>	DART AEROSPACE LTD	
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CHECKED	<i>ASS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>JH</i>	D4542	SHEET 3 OF 5
APPROVED	<i>JH</i>	TITLE	SCALE
DE APPR.	<i>JH</i>	RETAINER, INNER	NTS
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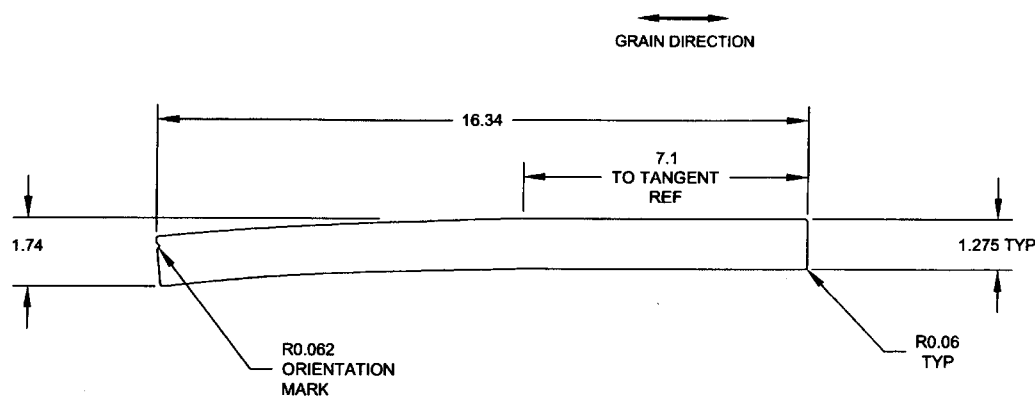
D4542-5 RETAINER, INNER
(TOP CORNER)

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4542-5-REVD.DXF"

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2013-04-23
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D4542-7 RETAINER, INNER
(TOP)



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2013-04-22

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs
- 8) PROFILE PER DRAWING FILE "D4542-7-REVD.DXF"

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CHECKED	ASS	DRAWING NO.	REV. D
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